

Work Order ID 68206

Page 1

Friday, April 08, 2011 11:48:28 AM

Item ID: D3238-13

Accept



Setup Start



Revision ID:

Item Name: Plate

Stop



Start Date: 4/8/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: */*Date: *4/04/11*

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3238	Rev C								<i>MAT NOT PULLED</i>

100



FLOW WATER JET

Waterjet

Memo

0.00

B114-25

FLOW CNC Waterjet

*5052 . 620*1-Cut as per Dwg D3238 Dwg Rev: *C* Prog Rev: *C* 2-
Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

B114-25

QC

Quality Control

120



QC8- Inspect parts - second check

0.00

*8 w/04/27**CERT**072*

QC

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3238-13

Accept



Setup

Start



Revision ID:

Item Name: Plate

Stop



Start Date: 4/8/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

22 / 11-04-28.

Hand Finishing

Memo

0.00

6

140



QC3- Inspect Part Finish

0.00

22 / 4 / 11-04-26

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: 042

0.00

P-14/28 (22)

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 68206

Friday, April 08, 2011 11:48:28 AM



Page 3

Item ID: D3238-13

Accept



Setup Start



Revision ID:

Item Name: Plate

Stop



Start Date: 4/8/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11/04/28
D

Memos

0.00

WP
11/04/28

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Friday, April 08, 2011 11:48:34 AM

Page 1

Work Order ID: 68206



Parent Item: D3238-13



Parent Item Name: Plate

Start Date: 4/8/2011

Required Date: 4/12/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-10-20 EC
IPP Rev:B Now on Waterjet 07-01-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.020		Purchased		No		100	sf	0.0000	0.012	0.151579			

5052-H32 .020 Sheet

6061 - .020

m6061H32S.020

M 112442

(20)

1811-4-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	68204
Description: Plate	Part Number:	D3238-13
Inspection Dwg: D3238 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>B</u>	Audited by:	<u>J</u>	Prototype Approval:	N/A
Date:	11-4-25	Date:	4/04/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.02.23	Dwg Rev. updated	KJ/JLM	Z

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

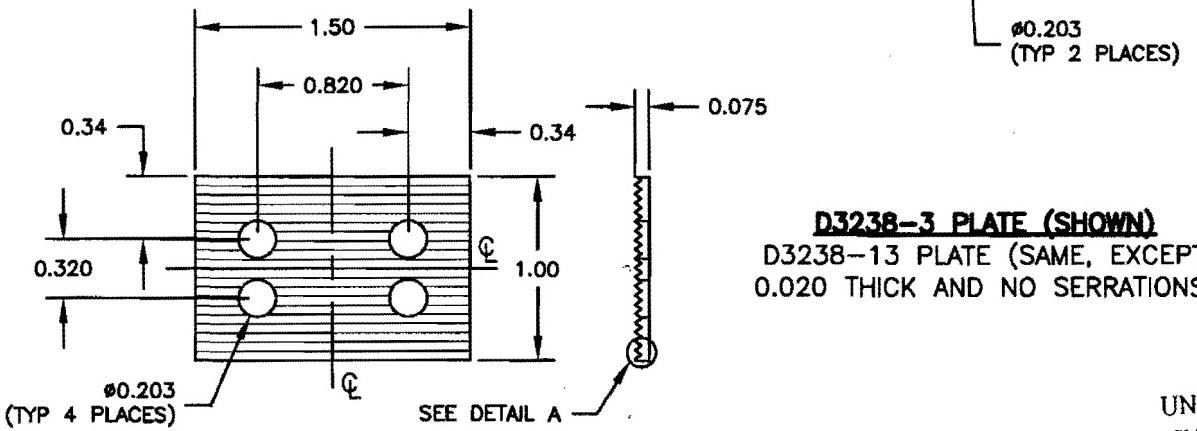
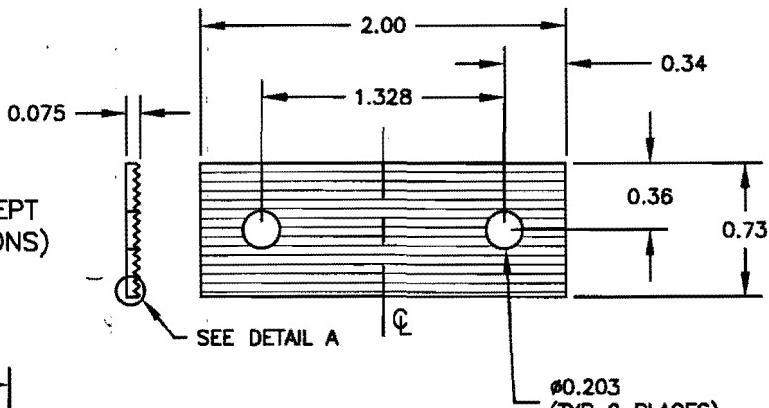
DESIGN <i>AF</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D3238	REV. C	SHEET 1 OF 3
DATE 07.02.19		TITLE PLATE	SCALE 1:1	
A	03.11.25	NEW ISSUE		
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6		
C	07.02.19	ADD 5052-H32 OPTION		

RELEASED

07.02.20 aff

D3238-1 PLATE (SHOWN)

D3238-11 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



D3238-3 PLATE (SHOWN)

D3238-13 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

ONS) SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

NOTES:

- 1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037 NO. A804
(REF DART SPEC M2024T3S)
-11/-13/-15/-31/-33/-35 PLATE:
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)
OR
ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR
AMS 4016 (REF DART SPEC M5052H32S.020)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) SEE SHEET 3 FOR DETAIL A

7) PARTS ARE SYMMETRIC ABOUT $\frac{1}{4}$

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

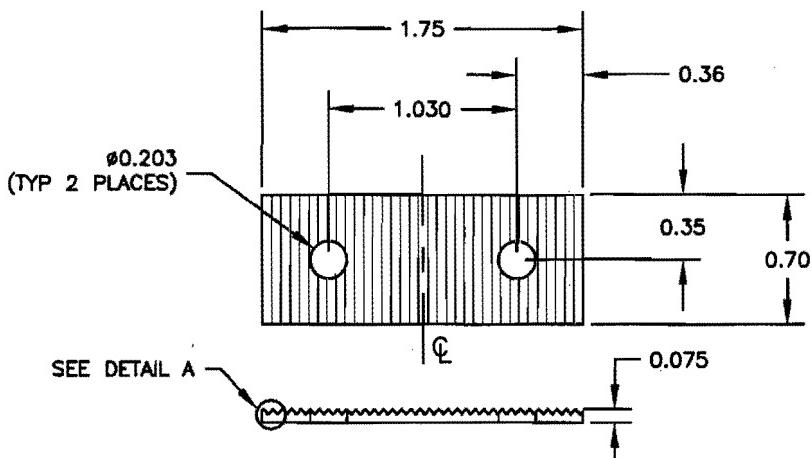
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

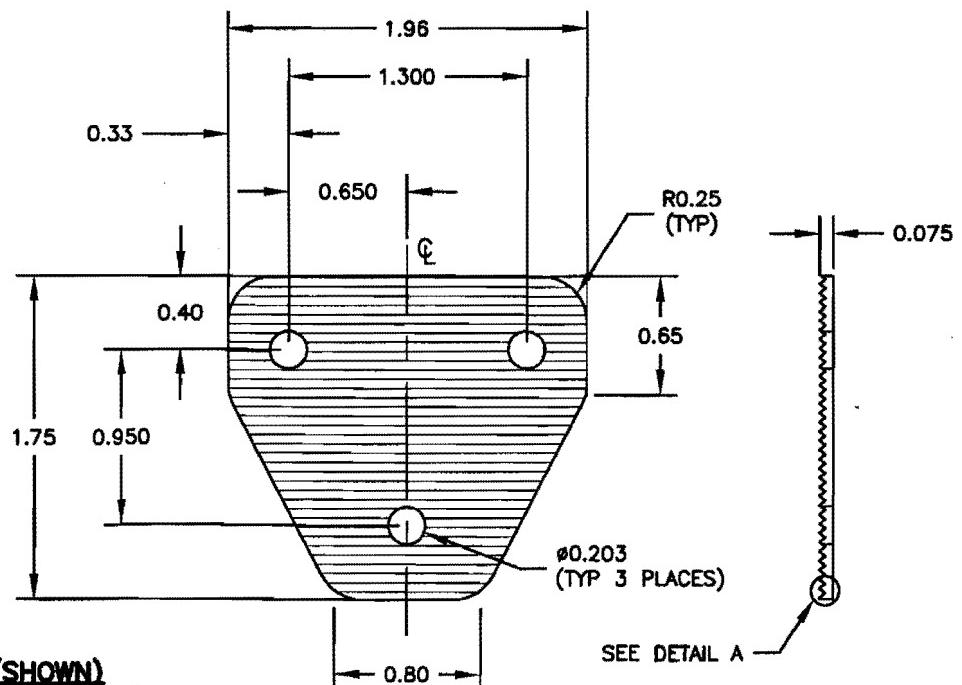
DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED CE	APPROVED H	DRAWING NO. D3238
DATE 07.02.19		TITLE PLATE

REV. C
SHEET 2 OF 3
SCALE 1:1



D3238-5 PLATE (SHOWN)
D3238-15 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



D3238-21 PLATE (SHOWN)
D3238-31 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

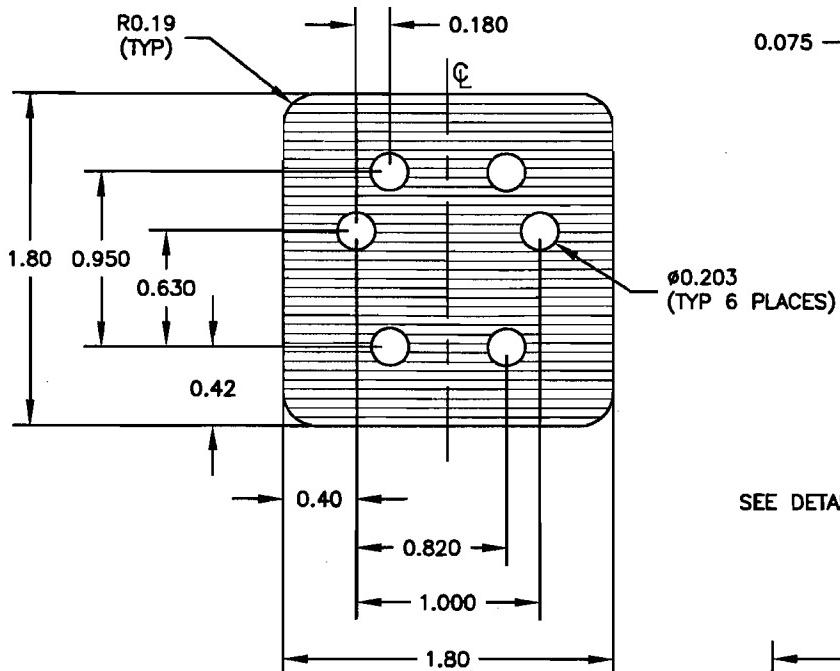
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

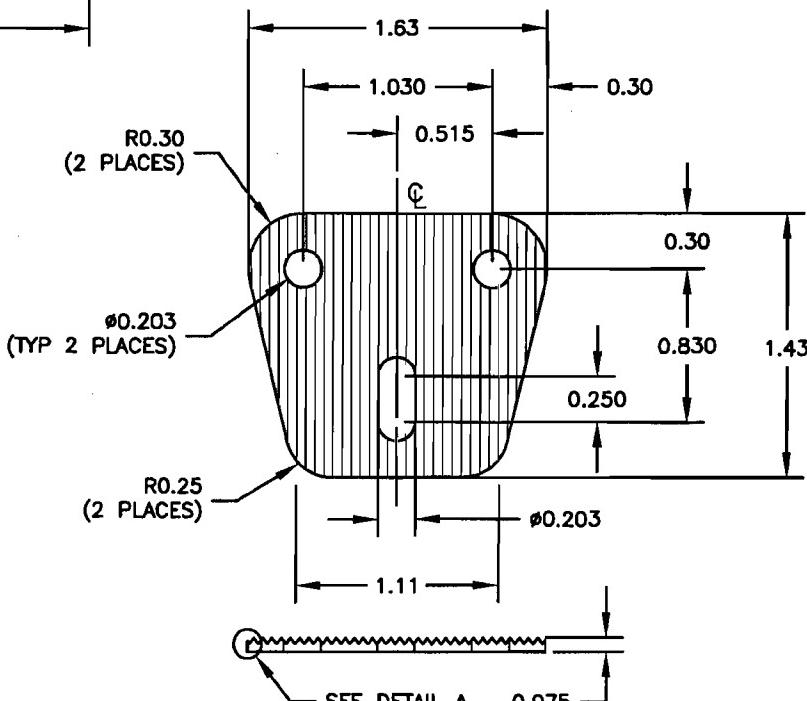
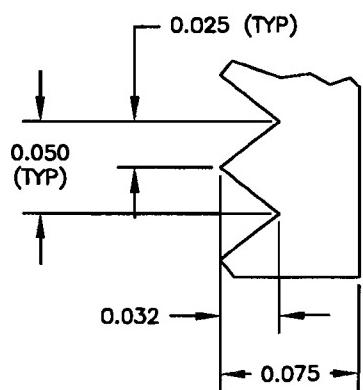
DESIGN <i>4</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D3238	REV. "C" SHEET 3 OF 3
DATE 07.02.19		TITLE PLATE	SCALE 1:1



RELEASED
07.02.20 *CH*

D3238-23 PLATE (SHOWN)
D3238-33 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

u/o 6 8206



DETAIL A
RIDGE DETAIL (VIEW MAY BE ROTATED)
SCALE 10:1

D3238-25 PLATE (SHOWN)
D3238-35 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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